

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

December-17-14 1:14:24 PM

Reference:

Stop ***NR2***

130

130

Small Fab

Small Fab

NC BRAKE

Memo

C'SINK HOLES AS PER DWG

Set Up/ Run Hours

0.00

0,00

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

DAS
36
9-89

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
38
9-89

JAN 06 1965

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

3 of 15-1-6 Doc

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Work Order ID 127344

127344

Page 4

Item ID: D4463-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Top Assembly
 Start Date: 12/17/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location <u>WAGSS</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

3 JAN 07 2015
 DAS
 06
 9-89

MJ 15-01-08

45-1-8

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:14:24 PM

Page 1

Work Order ID: 127344

127344

Parent Item: D4463-041

D4463-041

Parent Item Name: Tank Top Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC
12.04.25 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 *M6061T6S 063* 6061-T6 .063 Sheet		Purchased	No			100	sf	142.0000	3.864	<u>5</u> <u>10</u>			DAS 23 9-89 15-1-5
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				142					
				M128941				18.5					
				M129845				38.5					
				M130096				25					
				M130745				60		130745			
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			170	Each	2,618.000	48	48		15/01/06	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2200					
				m127432				2200		144			
				MF4				36					
				125578				36					
				ST313				382					
				125578				382					
NAS1473R3 *NAS1473R3* Anchor Nut		Purchased	No			170	Each	145.0000	24	24		15/01/06	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				20					
				m127059				20		20			
				ST265				125					
				m129913				125		52			

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FAULT CATEGORY

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DART AEROSPACE LTD		Work Order:	127344
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463 Rev: D		Page 1 of 2	

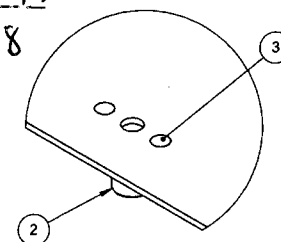
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	-		V	Jkmo1
Ø0.206	+0.005/-0.001	0.209"	-		V	
Ø1.00	+0.012/-0.001	1.000"	-		V	
1.15	+/-0.030	1.15"	-		V	
1.85	+/-0.030	1.85"	-		V	
2.20	+/-0.030	2.20"	-		V	
2.30	+/-0.030	2.30"	-		V	
5.29	+/-0.030	5.29"	-		V	
8.30	+/-0.030	8.30"	-		V	Jkmo8
8.93	+/-0.030	8.93"	-		V	
8.98	+/-0.030	8.98"	-		V	
9.31	+/-0.030	9.31"	-		V	
10.42	+/-0.030	10.42"	-		V	
11.26	+/-0.030	11.26"	-		V	
1.61	+/-0.030	1.61"	-		V	
1.68	+/-0.030	1.68"	-		V	
1.82	+/-0.030	1.82"	-		V	
3.41	+/-0.030	3.41"	-		V	
3.79	+/-0.030	3.79"	-		V	
6.43	+/-0.030	6.43"	-		V	
7.36	+/-0.030	7.36"	-		V	
7.80	+/-0.030	7.80"	-		V	
10.75	+/-0.030	10.75"	-		V	
11.38	+/-0.030	11.38"	-		V	
11.80	+/-0.030	11.80"	-		V	
13.27	+/-0.030	13.27"	-		T	
1.15	+/-0.030	1.15"	-		V	
3.00	+/-0.030	3.00"	-		V	
3.26	+/-0.030	3.26"	-		V	
7.00	+/-0.030	7.00"	-		V	
10.74	+/-0.030	10.74"	-		V	
11.00	+/-0.030	11.00"	-		V	
11.63	+/-0.030	11.63"	-		V	
15.29	+/-0.030	15.29"	-		T	
15.48	+/-0.030	15.48"	-		T	
19.48	+/-0.030	19.48"	-		T	
23.48	+/-0.030	23.48"	-		T	
23.67	+/-0.030	23.67"	-		T	
24.11	+/-0.030	24.11"	-		T	
27.46	+/-0.030	27.46"	-		T	

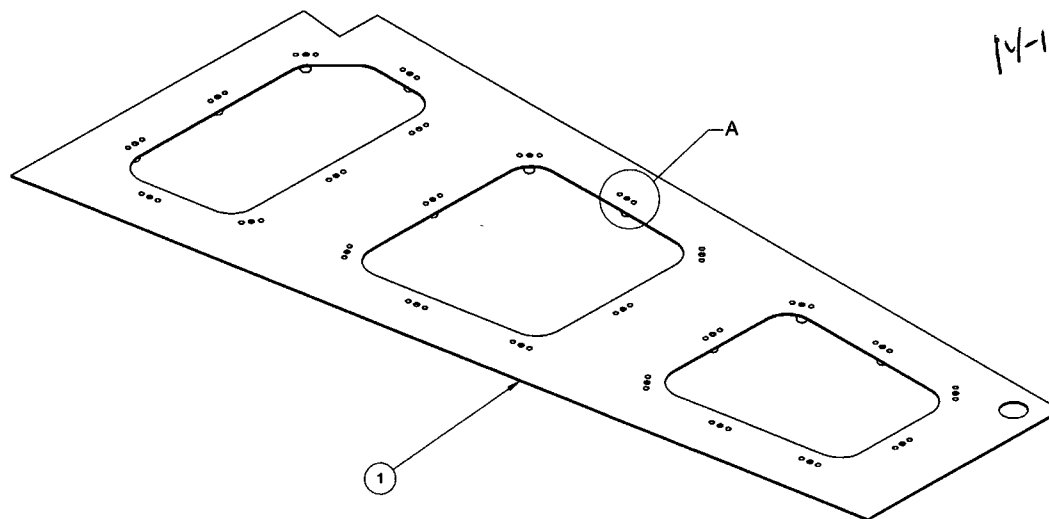
ITEM NO.	QTY -041	PART NUMBER	DESCRIPTION
	X	D4463-041	TANK TOP ASSEMBLY
1	1	D4463-1	TANK TOP
2	24	NAS1473-3	ANCHOR NUT
3	48	MS20426AD3-4	RIVET, CSK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 127344 ML5

14-12-18



DETAIL A
24 PL



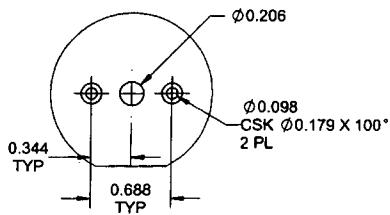
D4463-041 TANK TOP ASSEMBLY

RELEASED
2014-06-11

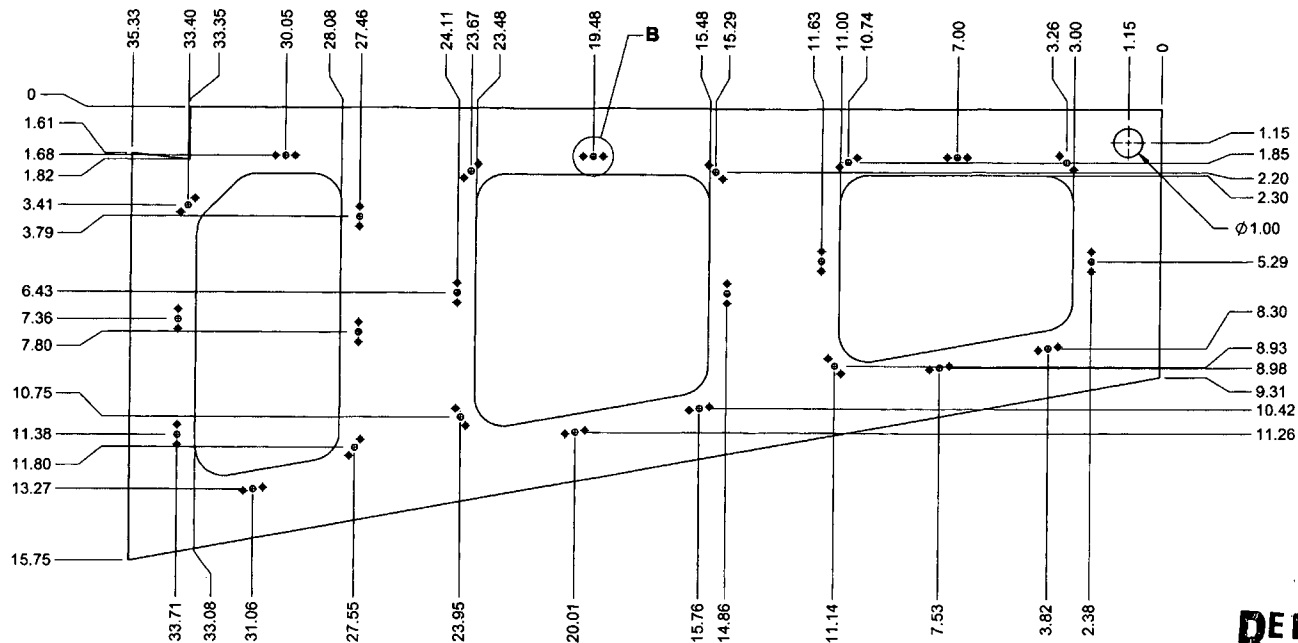
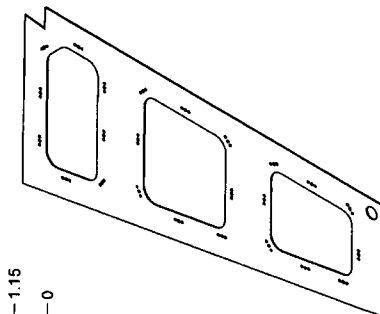
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.77 lbs

D	ADDED RIVET PILOT HOLES TO D4463-97-11 SHEET 9-12, REF NCR 13-3100 UPDATED D4463-3F (83-4)	ML	14.05.13
C	ADD DIMS: ZN B5-5, D5-5, B2-11, B7-11, D3-11. ADD -13, MODIFY -1/-11.	DC	12.03.23
B	ADD D4463-041, ZN C5-1, UPDATED -1/-3/-5/-7/-9, COMBINED -11 & -13 INTO -11.	DC	11.12.14
A	NEW ISSUE	DC	11.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4463	SHEET 1 OF 14
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	AUX TANK	NTS
DATE	14.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



DETAIL B
(24 PL)



D4463-1 TANK TOP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.70 lbs

RELEASED
2014-06-11

APPROVED

DESIGN	ML
DRAWN	ML
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4463** REV. D
SHEET 2 OF 14

TITLE **AUX TANK** SCALE NTS

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